

Two-color mold is two kinds of plastic materials injection molding in the same injection molding machine, divided into two molding, but the product is only a mold die. In general, this molding process is also referred to as two-shot molding and is usually completed by a set of molds and requires a special two-color injection molding machine.

Two-color molds are increasingly popular on the market. This process can make the appearance of products more beautiful, easy to change color and can not spray, but the cost is expensive and technical requirements are high.

1. The two shapes of the master mold are different, and one type of product is formed respectively, and the two shapes of the male mold are exactly the same.

Common Zhuo Zhuo two-color mold picture

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2. Before and after the mould is rotated 180o in the center, it must match. This inspection must be done during the design process.

3. The total thickness of the front mold panel plus the A plate must not be less than 170mm. Please check the other reference data for this type of injection molding machine, for example, the maximum mold thickness, the minimum mold thickness, KO hole distance, etc.

4. The nozzle of the three-plate die can be designed to be able to automatically release the mold. Special attention should be paid to whether the soft glue outlet is capable of being ejected*.

5. When designing the second injection molding master mold, in order to prevent the secondary mother mold from inserting (or rubbing) and hurting the gel part of the product that has been molded for the first time, part of the design may be avoided. However, the strength of each seal must be carefully considered. That is, in plastic injection, will there be a large deformation of the plastic under the injection pressure, which may result in the possibility of a second front injection.

6. When injection molding, the size of the first injection molded product can be slightly larger so that it can be pressed tightly with another male mold during the second molding to achieve the function of the sealant.

7. At the second injection molding, will the flow of plastic impulsion to the product that has been molded for the first time to deform the gel position? If this is possible, it must be improved.